

Date: Monday, 18/08/2008 4:03:40 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services			<b>Drawing Name</b>	: STEP HI LONG		
<b>Job Number</b>	: 41344			<b>Part Number</b>	: D32721		
<b>Estimate Number</b>	: 12897			<b>Drawing Number</b>	: D3272 REV B		
<b>P.O. Number</b>	:			<b>Project Number</b>	: N/A		
<b>This Issue</b>	: 18/08/2008			<b>Drawing Revision</b>	: B		
<b>Prsh Rev.</b>	: NC			<b>Material</b>	:		
<b>First Issue</b>	: 18/08/2008			<b>Due Date</b>	: 15/09/2008		
<b>Previous Run</b>	: 41033			<b>Qty:</b>	20		
<b>Written By</b>	:			<b>Um:</b>	Each		
<b>Checked &amp; Approved By</b>	<u>JUL 08.8-18</u>						
<b>Comment</b>	: Est Rev:A New Issue 07-06-09 JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2622120C	Step Extrusion	
		<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)	
		Pick:	
	Qty Part Number	Description Batch	
	1 D2622-120	Extrusion <u>B40437</u>	<u>SAI 08/09/03 20</u>
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		<b>Comment:</b> LARGE FABRICATION RESOURCE 1	
		1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A	<u>JK 08.09.03</u>
		2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.	<u>JK 08.09.03</u>
		3-Deburr	<u>JK 08/09/03 20</u>
3.0	QC5	INSPECT WORK TO CURRENT STEP	
		<b>Comment:</b> INSPECT WORK TO CURRENT STEP	<u>S 08/09/03 100</u>
4.0	PACKAGING 1	PACKAGING RESOURCE #1	
		<b>Comment:</b> PACKAGING RESOURCE #1	
		Identify and Stock	
		Location: <u>W</u>	<u>SAI 08/09/03 20</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: STEP HI LONG
Job Number:	41344	Part Number: D32721
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
5.0	QC21	FINAL INSPECTION/W/O RELEASE
		 08/09/04/J
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion	 MF 08-09-03	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>QP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

**RELEASED**07 06 04 *H*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

**GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

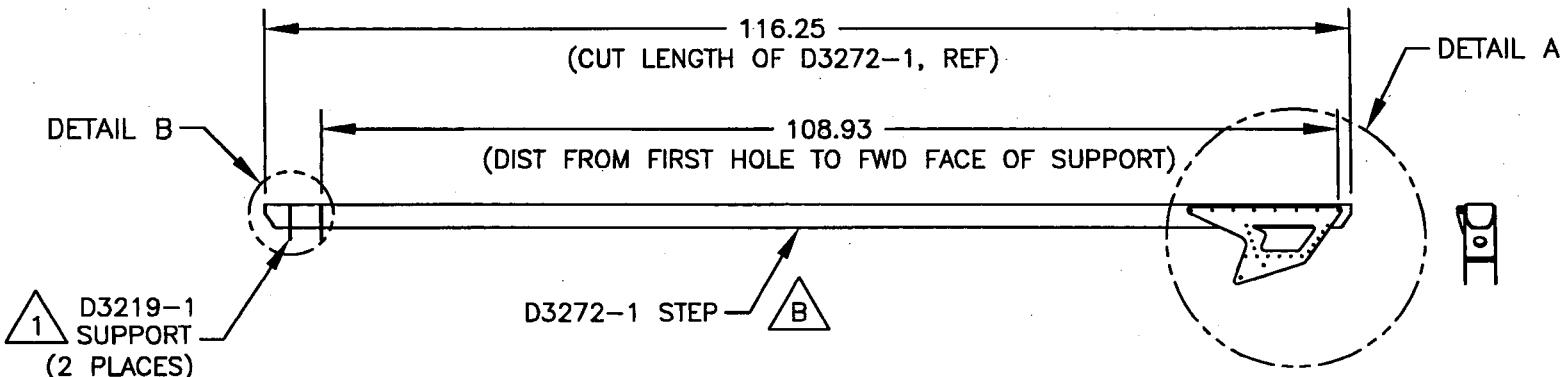
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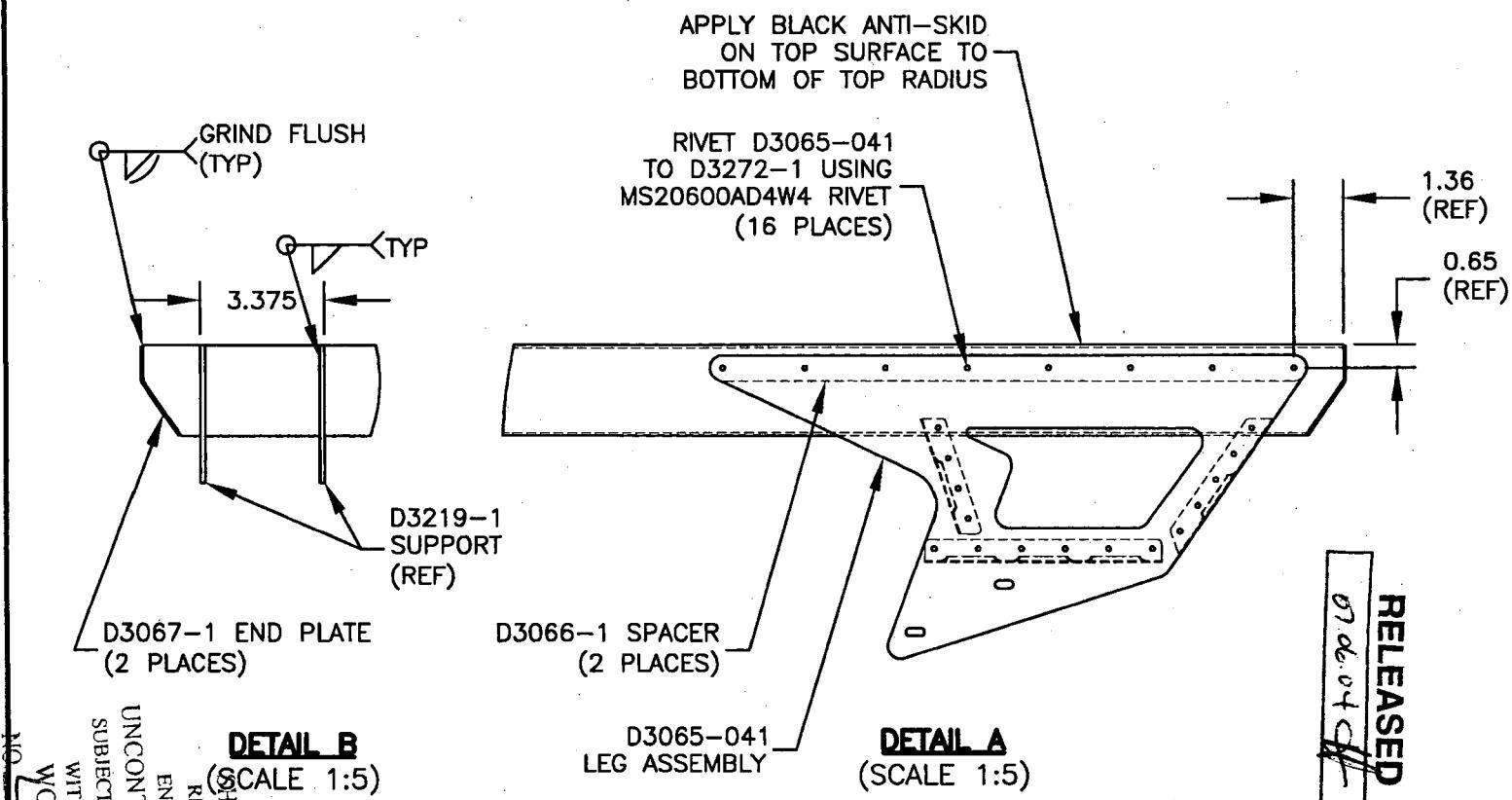
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**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	DRAWING NO.
<i>CE</i>	<i>[Signature]</i>	D3272
DATE	07.05.18	TITLE
		STEP ASSEMBLY, LH LONG
		SHEET 2 OF 3
		SCALE
		1:20



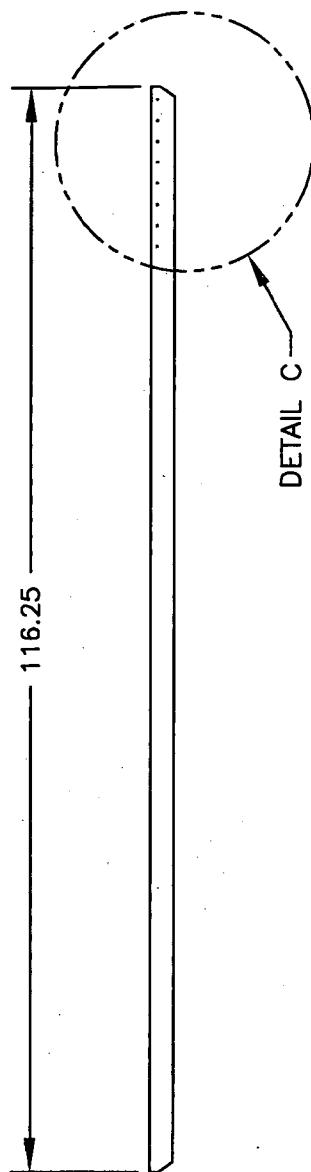
**D3272-041 STEP ASSEMBLY (LH, SHOWN)**  
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



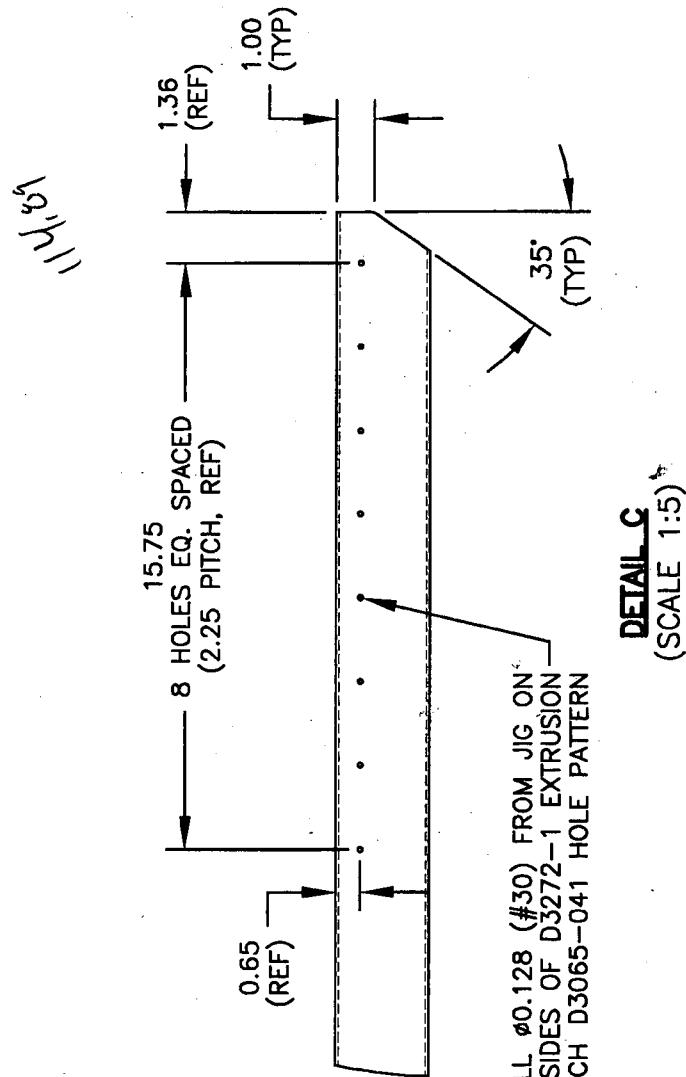
RELEASED  
07.06.04 C.H.

**DART**

DESIGN <i>QP</i>	DRAWN BY <i>BS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>sf</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20



**B D3272-1 STEP**  
(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL #0.128 (#30) FROM JIG ON  
BOTH SIDES OF D3272-1 EXTRUSION  
TO MATCH D3065-041 HOLE PATTERN

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *41374*

**RELEASED**

07.06.04 *sf*